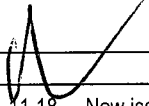


Date: Tuesday, 13/05/2008 10:09:59 AM
 User: Linda Lacelle

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : DOUBLER |
| Job Number : 39187 | |
| Estimate Number : 11321 | |
| P.O. Number : | Part Number : D33081 |
| This Issue : 13/05/2008 S.O. No. : | Drawing Number : D3308 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : A |
| Previous Run : 39187 | Material : |
| Written By :  | Due Date : 30/05/2008 Qty: 6 Um: Each |
| Checked & Approved By : | |
| Comment : Est A 04.11.18 New issue KJ/JLM Est Rev:B 08-05-12 now made on water jet DD verified by:EC | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M6061T6S063 | 6061-T6 .063 Sheet |
|-----|-------------|--------------------|



3



Comment: Qty.: 0.0329 sf(s)/Unit Total : 0.1972 sf(s)

6061-T6 .063 Sheet

Material: 6061-T6 (QQ-A-250/11) 0.063" thick

M6061T6S.063)

Identify for D3308-1

Batch: 107387 IB 8-5-14

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3308

Dwg Rev: A IB 8-5-14

Prog Rev: A

2-Deburr if necessary

CB08/05/16 (7) (7) (7)

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



IB 8-5-14

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

**Comment:** SECOND CHECK

S08/05/16 (7) (7)

Date: Tuesday, 13/05/2008 10:09:59 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 39187

Part Number: D33081

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

Done at JED #22 08/05/16

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

212/F2 08/05/16

(7)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AS 08/05/20 (7)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: ST 83

AS 08/05/20 (x7)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/20

Job Completion

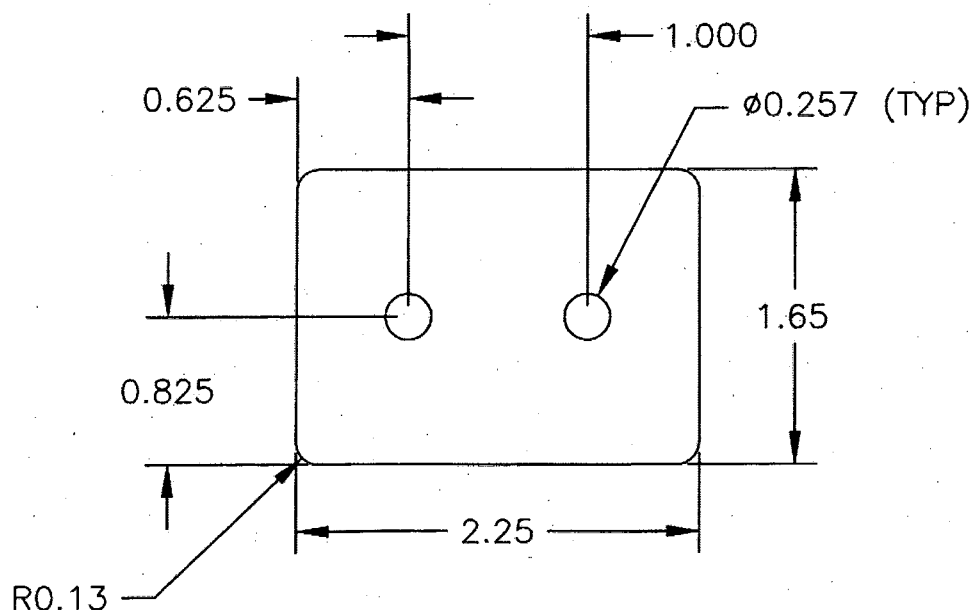


MF 08-05-20



| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN TJ | DRAWN BY TJ | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3308 | REV. A SHEET 1 OF 1 |
| DATE 04.10.13 | | TITLE DOUBLER | SCALE 1:1 |
| A | 04.10.13 | NEW ISSUE | |

RELEASED
04.11.23



D3308-1

D3308-1 NOTES:

- 1) MATERIAL: 6061-T6 SHEET (QQ-A-250/11), 0.063 THICK
(REF DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 39187

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